

Work Order ID 130992

March-26-15 1:34:17 PM

130992

Page 1

Item ID: D2002-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Knob

Start Date: 3/26/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 15-03-30

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2002

Rev A

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA005 & dwg

FOLIO REV: AA

DWG REV: N/A

2-Deburr as required

DAS
40
9-89

15/04/06

DAS
37
9-89

15.04.09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
40
9-89

15/04/06

DAS
37
9-89

15.04.09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D2002-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Knob

Start Date: 3/26/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 4.00

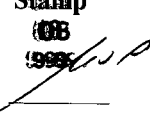
4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		S. 15/04/10		22	0		
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00				22			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

APR 13 2015

ML5 15-04-14

APR 4-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 130992

130992

Parent Item: D2002-015

D2002-015

Parent Item Name: Knob

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.05.18Added inspection level 8EC
IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINR1.2500

Purchased

No

f

16.0000

1

MDFI RINR1 2500

**

DAS

DEL RIN ROUND BAR 1.25" color: black

37 15-04-09
9-89

Location

Loc Qty

Loc Code

MAT039

16

→ m131782

16

1 ft

DQA: _____ Date: _____



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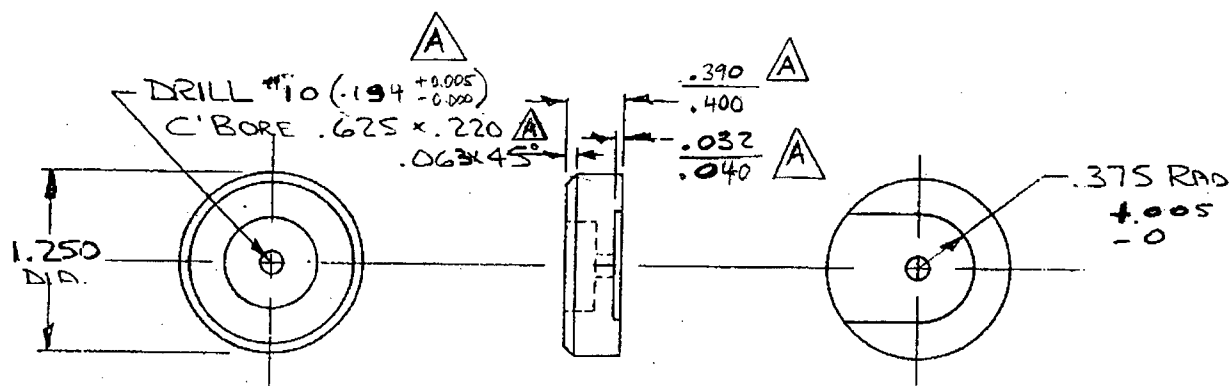
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19.12.09 DS



130992 MLS
1503-30

DETAIL OF DZ00Z-015

4/F: BLACK DELRIN OR
A BLACK UHMW PER D2689

REVISION DRAWN CHECKED APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF CHRYSLER. REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS IN: 3. REMOVE SHARP EDGES 0.015 MAX. 4. THREADS PER MIL. - S - 2742 5. HOLE PER ANSI 10317 LIMITS 1. TOLERANCES - JES & G30 2. ANGLES JES & 040 3. HOLE PER MIL. - S - 2742 4. PARALLELISM 0.0015 5. PERPENDICULARITY 0.0015 6. SYMMETRY ABOUT ALL 0.015 CENTRE LINES 0.015		PART CODE SHALL BE PER HAS 522 BASIC CODE DIA. DASH NO THREAD NEAR SIDE THREAD FAR SIDE IN OR OUT DASHING OF SHEETS OR CENTERLINE LENGTH DASH NO MIN. FOLDING BASIC CODES BAA=34201000 BB=34201002		QTY REQUIRED APPROVAL		PART NO. ITEM DESCRIPTION MATERIAL SPEC. VENDOR	
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS IN: 3. REMOVE SHARP EDGES 0.015 MAX. 4. THREADS PER MIL. - S - 2742 5. HOLE PER ANSI 10317		LIMITS 1. TOLERANCES - JES & G30 2. ANGLES JES & 040 3. HOLE PER MIL. - S - 2742 4. PARALLELISM 0.0015 5. PERPENDICULARITY 0.0015 6. SYMMETRY ABOUT ALL 0.015 CENTRE LINES 0.015		BASIC CODE DIA. DASH NO THREAD NEAR SIDE THREAD FAR SIDE IN OR OUT DASHING OF SHEETS OR CENTERLINE LENGTH DASH NO MIN. FOLDING BASIC CODES BAA=34201000 BB=34201002		CONTRACT NO. DESIGN DATE CLIENT TITLE CODE DWG. NO. SCALE SHT. OF		DART AERO ACCESSORIES INC. KNOB D 2002 1:1 1 OF 2	
REPORT ALL DISCREPANCIES - DO NOT SCALE									

7-0002-015